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International application number: PCT/US2004/019587

International filing date: 18 June 2004 (18.06.2004)

Document type: Certified copy of priority document

Document details: Country/Office: US
Number: 60/480,453
Filing date: 20 June 2003 (20.06.2003)

Date of receipt at the International Bureau: 12 January 2007 (12.01.2007)

Remark: Priority document submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b)



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APPLICATION NUMBER: 60/480,453

FILING DATE: *June 20, 2003*

RELATED PCT APPLICATION NUMBER: PCT/US04/19587

THE COUNTRY CODE AND NUMBER OF YOUR PRIORITY APPLICATION, TO BE USED FOR FILING ABROAD UNDER THE PARIS CONVENTION, IS *US60/480,453*



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PROVISIONAL APPLICATION FOR PATENT COVER SHEET

This is a request for filing a PROVISIONAL APPLICATION FOR PATENT under 37 CFR 1.53(c).

Express Mail Label No.

EV325929951US

U.S. PTO
17537
480453
06/20/03

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<input type="checkbox"/> Additional inventors are being named on the _____ separately numbered sheets attached hereto					
TITLE OF THE INVENTION (500 characters max)					
MANUFACTURING OF CONTROLLED POROSITY METALLIC TOOLS					
Direct all correspondence to: CORRESPONDENCE ADDRESS					
<input checked="" type="checkbox"/> Customer Number		<input type="text" value="000110"/>		Place Customer Number Bar Code Label here	
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ENCLOSED APPLICATION PARTS (check all that apply)					
<input checked="" type="checkbox"/> Specification Number of Pages		<input type="text" value="6"/>		<input type="checkbox"/> CD(s), Number	
<input checked="" type="checkbox"/> Drawing(s) Number of Sheets		<input type="text" value="1"/>		<input checked="" type="checkbox"/> Other (specify)	
<input type="checkbox"/> Application Data Sheet. See 37 CFR 1.76		<input type="text" value="Claims: 1 page"/>			
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<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27.		<input type="checkbox"/> A check or money order is enclosed to cover the filing fees		FILING FEE AMOUNT (\$) \$160.00	
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<input type="checkbox"/> Yes, the name of the U.S. Government agency and the Government contract number are: _____					

Respectfully submitted,

SIGNATURE

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215-563-4100

Date

06/20/2003

REGISTRATION NO.
(if appropriate)
Docket Number:

31,049

0008-CA323PRO

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06/20/03

13408 U.S. PTO

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FEE TRANSMITTAL for FY 2003

Effective 01/01/2003. Patent fees are subject to annual revision.

☐ Applicant claims small entity status. See 37 CFR 1.27

TOTAL AMOUNT OF PAYMENT (\$ 160.00)

Complete if Known

Application Number	not assigned yet
Filing Date	06/20/2003
First Named Inventor	Louis William LHERBIER
Examiner Name	
Art Unit	
Attorney Docket No.	0008-CA323PRO

METHOD OF PAYMENT (check all that apply)

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04-1406

DannDorfmanHerrell&Skillm

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FEE CALCULATION

1. BASIC FILING FEE

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
1001 750	2001 375	Utility filing fee	
1002 330	2002 165	Design filing fee	
1003 520	2003 260	Plant filing fee	
1004 750	2004 375	Reissue filing fee	
1005 160	2005 80	Provisional filing fee	160.00

SUBTOTAL (1) (\$ 160.00)

2. EXTRA CLAIM FEES FOR UTILITY AND REISSUE

Total Claims	Extra Claims	Fee from below	Fee Paid
Independent Claims	-20** =	X	
Multiple Dependent	-3** =	X	

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description
1202 18	2202 9	Claims in excess of 20
1201 84	2201 42	Independent claims in excess of 3
1203 280	2203 140	Multiple dependent claim, if not paid
1204 84	2204 42	** Reissue independent claims over original patent
1205 18	2205 9	** Reissue claims in excess of 20 and over original patent

SUBTOTAL (2) (\$)

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FEE CALCULATION (continued)

3. ADDITIONAL FEES

Large Entity Small Entity

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
1051 130	2051 65	Surcharge - late filing fee or oath	
1052 50	2052 25	Surcharge - late provisional filing fee or cover sheet	
1053 130	2053 130	Non-English specification	
1812 2,520	2812 2,520	For filing a request for ex parte reexamination	
1804 920*	2804 920*	Requesting publication of SIR prior to Examiner action	
1805 1,840*	2805 1,840*	Requesting publication of SIR after Examiner action	
1251 110	2251 55	Extension for reply within first month	
1252 410	2252 205	Extension for reply within second month	
1253 930	2253 465	Extension for reply within third month	
1254 1,450	2254 725	Extension for reply within fourth month	
1255 1,970	2255 985	Extension for reply within fifth month	
1401 320	2401 160	Notice of Appeal	
1402 320	2402 160	Filing a brief in support of an appeal	
1403 280	2403 140	Request for oral hearing	
1451 1,510	2451 1,510	Petition to institute a public use proceeding	
1452 110	2452 55	Petition to revive - unavoidable	
1453 1,300	2453 650	Petition to revive - unintentional	
1501 1,300	2501 650	Utility issue fee (or reissue)	
1502 470	2502 235	Design issue fee	
1503 630	2503 315	Plant issue fee	
1460 130	2460 130	Petitions to the Commissioner	
1807 50	2807 50	Processing fee under 37 CFR 1.17(q)	
1806 180	2806 180	Submission of Information Disclosure Stmt	
8021 40	28021 40	Recording each patent assignment per property (times number of properties)	
1809 750	2809 375	Filing a submission after final rejection (37 CFR 1.129(a))	
1810 750	2810 375	For each additional invention to be examined (37 CFR 1.129(b))	
1801 750	2801 375	Request for Continued Examination (RCE)	
1802 900	2802 900	Request for expedited examination of a design application	

Other fee (specify)

*Reduced by Basic Filing Fee Paid

SUBTOTAL (3) (\$)

SUBMITTED BY

(Complete if applicable)

Name (Print/Type)	Vincent T. Page	Registration No. (Attorney/Agent)	31,049	Telephone	215-563-4100
Signature	<i>Vincent T. Page</i>	Date	06/20/2003		

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MANUFACTURING OF CONTROLLED POROSITY METALLIC TOOLS

Louis William Lherbier
David James Novotnak

Background of the Invention

Plastic injection molding is a very large industry, and we rely on hundreds of plastic injection molded products every day. The list is endless, but includes interior automotive parts, cell phone cases and windows, caps and closures, children's toys, kitchen items, office equipment, etc. Even though great advances have been made in this industry, product complexity and production rates are still limited. These limitations do not result from the injection molding machines themselves, but rather from the restrictions imposed by tooling design and tooling materials used in the injection molding machines.

The known tools for injection molding machines are made from cast and wrought steel and have been available for over 50 years. The known injection molding tools exhibit a number of disadvantages. The known machines are designed so that air can vent from the mold cavity as it is filled with the plastic material. The tools are usually inefficiently cooled by water passing through channels drilled into the mold walls. Production efficiency is low because the plastic component must remain in the mold until it is solid enough to hold its shape and be ejected. Other features such as surface quality can also be impaired by cooling inefficiencies. Better and more consistent cooling of the mold would mean that the plastic solidifying temperature could be reached sooner, thus reducing cycle time, and increasing productivity.

Based on current knowledge of gas and gas usage, polymer processing techniques, and the metallurgy of tool materials, a new cooling technology has been developed which has been described as a major breakthrough for the plastic forming

industry and especially for plastic injection molding. This technology holds promise for increased productivity, greater design freedom for complex products, increased profits and a widened product scope because it has the potential to reduce production cycle times by 20 to 40%.

The new technology is an advanced cooling concept in which liquid cooling gas is injected into the mold where it evaporates. The resulting gas vents from the mold. This technology requires a mold material manufactured with uniform and controlled porosity to effect optimum cooling. By using micro pores in the mold material, the evaporative cooling points can be situated close to the forming surface of the mold. There is no restriction on the geometry of the mold in the same way as molds made with drilled water channels.

While the technology of gas cooling is viable, the difficulty has been the availability of a suitable material for the molds and the inability to obtain a controlled and consistent quality level of microporosity in the mold material. Further, no efficient technique was available to manufacture a composite mold with a porous interior and a solid surface layer, as is required in many applications where surface quality is of paramount importance.

Attempts to manufacture such tooling by conventional powder metallurgy press-and-sinter techniques have failed to produce the desired results. Those techniques cannot produce the required porosity levels with the degree of control required. Moreover, the press-and-sinter technique produces a non-uniform pore size in the tool material. With this type of variation, the cooling of the tool surface cannot be controlled, and the positives of the new gas cooling technique cannot be effectively utilized. Further, conventional powder metallurgy press and sinter technology cannot produce a solid surface on the tool, while at the same time producing a controlled and consistent microporous substructure.

It is clear that a material and process needs to be developed to manufacture tooling that can take advantage of the new gas cooling concept for plastic injection molding tools and molds. The process according to the present invention involves the utilization of corrosion resistant materials in combination with a powder metallurgy consolidation process that can produce a microporous tool with controlled porosity and pore size. Further, the consolidation technology according to this invention can produce composite tools designed to have both solid surfaces and porous areas as required for a particular application. Unlike other powder metallurgy consolidation processes, the process according to the present invention provides higher pressure, lower consolidation temperatures, and lower cycle times by orders of magnitude. These advantages result in lower manufacturing costs and significantly lower capital investment.

This new process of manufacturing controlled and uniformly consistent microporous corrosion resistant tool products will not only increase plastic injection molding productivity by 20 to 40%, but also eliminate many inherent cooling and quality difficulties common with conventional mold technology. Because the molds are porous, air can vent through the walls of the mold as the plastic material is being injected. This eliminates the venting problem of conventional molds. In addition, after injection of the plastic into the mold cavity, a small amount of liquid gas can be injected into the mold to release the part quickly and easily. The result will be fewer jammed injection machines, and fewer rejects for ejector marks. Overall, this technology provides tooling for plastic injection molding that has part cooling, air venting, and surface quality advantages over tooling currently used in the industry.

Detailed Description

The present invention includes a process for manufacturing a corrosion resistant, microporous material product with open and/or closed surfaces that can be used to effect uniform and consistent cooling of tools used for plastic injection

molding. The process initially involves producing gas atomized powder metals by known powder metallurgy techniques. In a second step, a shaped container is prepared for holding the powdered metal. The powder-filled container is heated to an appropriate temperature and then consolidated. The assembly is consolidated quasi-isostatically in a liquid medium at controlled pressure by means of a standard hydraulic press. The consolidation process is essentially a one-step operation.

A preferred embodiment of the process according to the present invention will now be described with reference to Figure 1 of the drawings. The material for the microporous tool is selected in accordance with the operating environment of the plastic injection molding process and the components to be manufactured. The gas atomized metal powder is screened to a particle size distribution consistent with the porosity level, pore size, and strength required by the mold application. Powder particle size is not a critical variable. Therefore, a wide range of powder particle sizes can be used for cost effectiveness. Good results have been obtained with powder particle sizes of -80 mesh and smaller. However, it will be appreciated that different sizes may be more appropriate for other types of injection molding tools. The screened powder is vibration filled into a shaped container. The shape of the container is dictated by the physical design of the injection mold. The powder-filled container is evacuated, sealed by crimping the evacuation nozzle, and then welded shut.

Consolidation of the metal powder proceeds as follows. The powder/container assembly is placed in an open metal vessel in which it is surrounded by glass frit. The metal vessel containing the powder/container assembly and the glass frit is placed into a furnace. The metal vessel is heated to a temperature appropriate for the tool material and high enough to melt and liquify the glass frit. After an appropriate time to reach temperature uniformity, the vessel/container assembly is removed from the furnace. It is placed in a pot die that is placed or located in a hydraulic press. Sufficient pressure is applied with the press to the assembly in the pot die to consolidate the metal powder

while retaining the desired amount of porosity. The pressure transfer medium in the pot die is a molten but highly viscous glass frit. After pressing, the consolidated powder and container assembly is ejected from the press and allowed to cool to room temperature. Figure 2 (upper) shows a fully porous tool blank made by the process according to the present invention.

Consolidation trials on alloys 420 LC and H13 have demonstrated that porosity can be controlled from a low of 60% dense to 100% dense. Pore size can also be controlled by process variables. Key variables of the process include powder particle size, consolidation temperature, and the pressure exerted by the hydraulic press. A preferred temperatures range is about 1850°F to about 2050°F. A preferred forging pressure range is about 250 tons to about 600 tons. The liquid glass media exerts a quasi-isostatic pressure on the containerized metal powder and produces a substantially uniform porosity throughout the entire product. Additionally, the relatively low pressing temperatures help prevent the formation of deleterious phases in the matrix material that may form in complex alloys at the higher temperatures used in the conventional powder metallurgy consolidation processes.

Surface finish is critical for some injection molded plastic parts and a fully porous tool would not provide the desired surface finish. To resolve that problem, composite tools with areas of solid and porous structure, as well as composite tools with varying material compositions, can also be produced by a process according to another aspect of the present invention. The alternate procedure includes the placement of a piece of a solid, cast and wrought, material in the metal container prior to filling in the metal powder. The metal container is then filled with the metallic powder and consolidated as described above. The metal powder bonds to the solid material during the consolidation step. The resulting tool product has a composite structure consisting of a fully dense surface layer and an internal porous substructure. Figure 2 (lower) shows a composite tool blank made by the process according to this invention. This

composite structure provides a tool that has a good surface for interfacing with the plastic part while still providing the desired cooling effect afforded by the porous substructure.

In view of the foregoing description, some of the novel features and advantages of the process according to the present invention should now be apparent. The process according to this invention can produce controlled porosity levels in plastic injection molding tools more uniformly and at lower costs than the known powder metallurgy consolidation techniques. Both large and small tools with uniform porosity can be produced by the process. The use of this process to manufacture tools for plastic injection molding will have a significant positive economic impact on this very important industry.

WHAT IS CLAIMED IS:

1. A process for making a metal tool having controlled porosity, comprising the steps of:

- (a) preparing metal powder by gas atomization;
 - (b) filling a metal container with the metal powder;
 - (c) placing the powder-filled container in a metal vessel;
 - (d) surrounding the powder-filled container in the metal vessel with glass frit;
 - (e) heating the metal vessel to temperature sufficient to melt the glass frit;
- and then
- (f) compacting the metal vessel under sufficient pressure to partially consolidate the metal powder so as to retain a desired amount of porosity therein.

2. A process for making a composite metal tool having controlled porosity, comprising the steps of:

- (a) preparing metal powder by gas atomization;
 - (b) placing a piece of a fully consolidated metal in a metal container;
 - (c) filling the metal container with the metal powder;
 - (d) placing the powder-filled container in a metal vessel;
 - (e) surrounding the powder-filled container in the metal vessel with glass frit;
 - (f) heating the metal vessel to temperature sufficient to melt the glass frit;
- and then
- (g) compacting the metal vessel under sufficient pressure to bond the metal powder to the fully consolidated metal piece and to partially consolidate the metal powder so as to retain a desired amount of porosity therein.

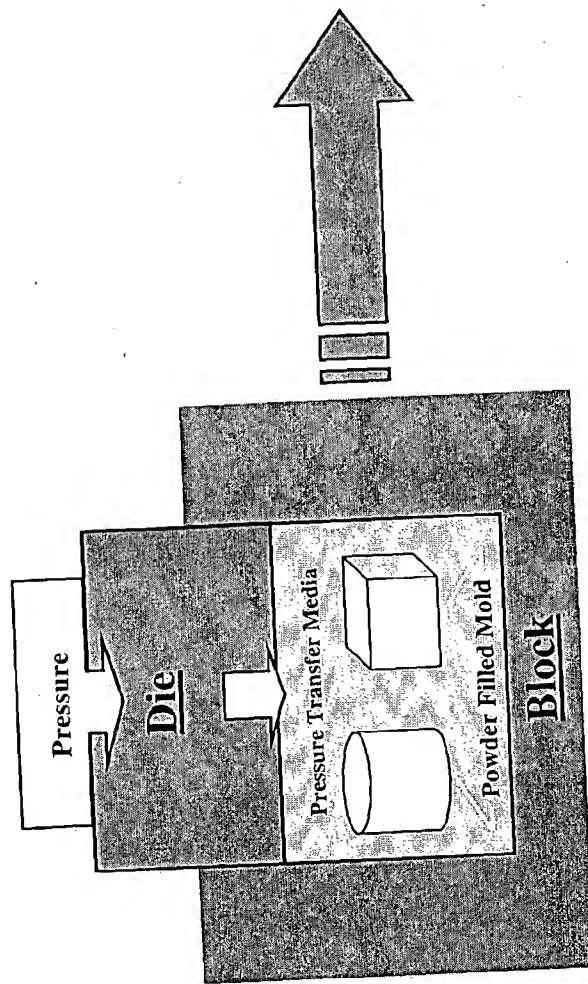


Figure 1 Quasi isostatic compaction of shaped containers

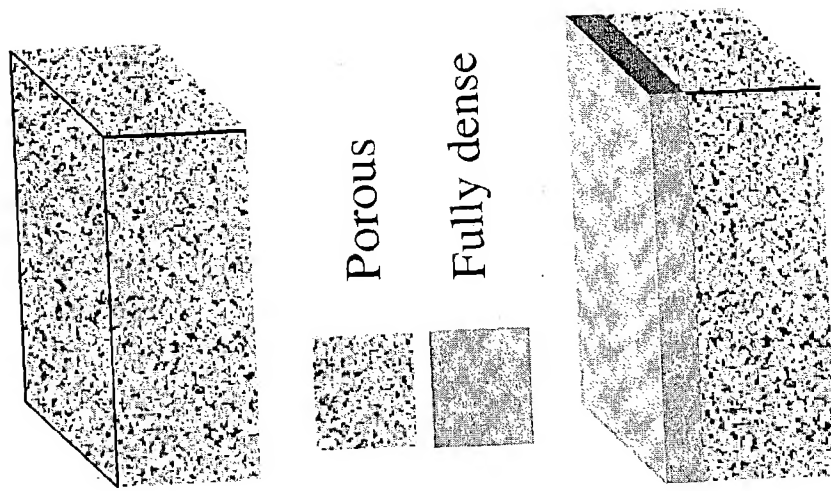


Figure 2 Resultant tool blank as porous or combination porous-fully dense